

Work Order ID 111961

January-29-14 10:57:17 AM

111961

Page

Item ID: D4634-043

Revision ID:

Item Name: Middle, Center Ceiling Panel Assembly

Start Date: 30/01/2014 Start Qty: 1.00

Required Date: 24/02/2014 Req'd Qty: 1.00

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2***1***

Cust Item ID:

1

Customer:

Approvals:

Process Plan: 

Date: 14-01-29

Tooling:

Date:

Run Start

NR1

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4634

E

100

0.00

100

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Pick Kit

① SAP 14/03/13

110

0.00

110

Small Fab

Memo

0.00

Small Fab

1- Assemble as per Dwg D4634-043

2- Install led lights

3- Install Air valves

4-Install wiring harness

① SAP 14/03/13

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January-29-14 10:57:17 AM

111961

Page 2

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Start Date: 30/01/2014 Start Qty: 1.00
Required Date: 24/02/2014 Req'd Qty: 1.00
Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____
QC: _____ Date: _____

Tooling: _____ Date: _____
SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

DAS

16

9-89

0.00

120

QC

Memo

Quality Control

130

Identify as per dwg & Stock Location: _____

0.00

130

Packaging

Memo

Packaging

0.00

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

Quality Control

0.00

DAS
06
9-89

MAR 14 2014

14-03-14

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Picklist Print

January-29-14 10:57:20 AM

Page 1

Work Order ID: 111961

111961

Parent Item: D4634-043

D4634-043

Parent Item Name: Middle, Center Ceiling Panel Assembly

Start Date: 30/01/2014

Required Date: 24/02/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev. A 12/08/09 New Issue DL
 12/11/08 Doc Release DL VERIFIED BY:JLM
 13/07/09 DL verf: DD
 DL
 IPP Rev B
 IPP Rev C Dwg Update
 IPP Rev. D Dwg Update 13/12/23
 IPP REV E Dwg Update 14/01/20 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4634-143		Manufactured	No			100	Each	0.0000	1	1			
D4634-143													
Middle, Center Ceiling Replacement Panel Assembly													
D4646-1		Manufactured	No			100	Each	50.0000	2	2			
D4646-1													
Plenum Cap Assembly													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST116		50							
				103832		50				2			
D4652-1		Manufactured	No			100	Each	217.0000	2	2			
D4652-1													
Air Valve, 1.16 Id Disk Type													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST099		191							
				111311		191							
				ST117		26							
				111779		26				2			
D4728-053		Manufactured	No			100	Each	2.0000	1	1			
D4728-053													
Cabin Lights #2													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST121		2							
				111205		2							

B112043 ** SAD 14/03/12

** SAD 14/03/12

** SAD 14/03/12

** SAD 14/03/12

B111203 (1)

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

January-29-14 10:57:21 AM

Page 2

Work Order ID: 111961

111961

Parent Item: D4634-043

D4634-043

Parent Item Name: Middle, Center Ceiling Panel Assembly

Start Date: 30/01/2014

Required Date: 24/02/2014

Start Qty: 1.00

Required Qty: 1.00

PLT1.5M-M

Purchased

No

100

Each

924.0000

3

3

PI T1 5M-M

Tie Wrap

SAD 14/03/12

Location

Loc Qty

Loc Code

ST389

924

124363

2

m126551

922

2351-20-27-C3C

Purchased

No

100

Each

149.0000

2

2

2351-20-27-C3C

STUD

SAD 14/03/12

Location

Loc Qty

Loc Code

ST396

149

m126740

27

m127922

42

m128068

80

50-009-2

Purchased

No

100

Each

800.0000

2

2

50-009-2

Grommet

SAD 14/03/12

Location

Loc Qty

Loc Code

ST378

800

122594

1

m128022

79

m128047

720

January-29-14 10:57:21 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

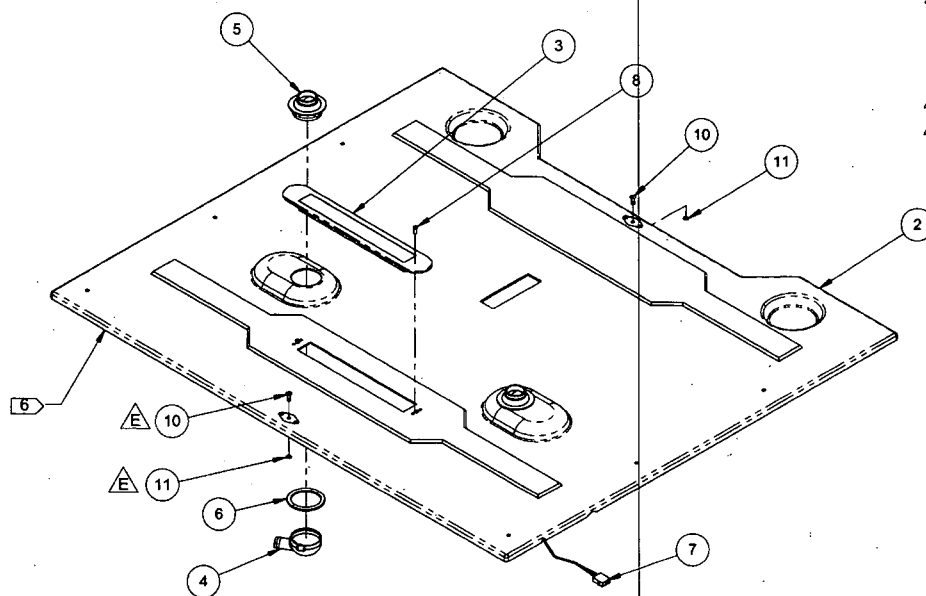
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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ITEM NO.	QTY. -043	PART NUMBER	DESCRIPTION
1	X	D4634-043	MIDDLE, CENTER CEILING PANEL ASSY
2	1	D4634-143	MIDDLE, CENTER CEILING REPLACEMENT PANEL ASSY
3	1	D4638-1 (REF)	LED LIGHT (REF PART OF D4728-051)
4	2	D4646-1	PLENUM CAP ASSEMBLY
5	2	D4652-1	AIR VALVE
6	2	D4652-3 (REF)	MOUNTING NUT (PART OF D4652-1)
7	1	D4728-053	CABIN LIGHT #2 HARNESS ASSEMBLY
8	2	N/A (REF)	SCREW (PART OF D4728-053)
9	3	PLT1.5M-M	TIE-WRAP (OR PLT1.5M-C)
10	2	2351-20-27-C3C	STUD
11	2	50-009-2	GROMMET



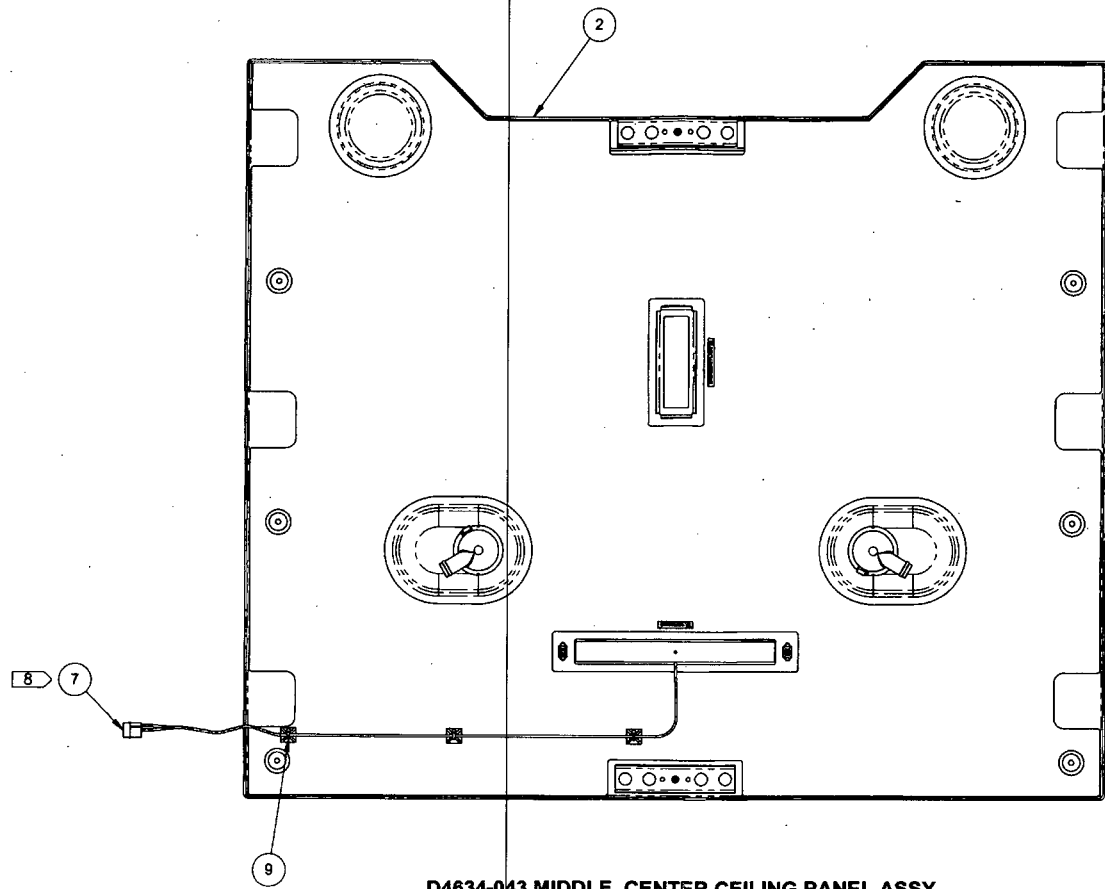
D4634-043 MIDDLE, CENTER CEILING PANEL ASSY

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4, ON SMOOTH SIDE
 - 7) WEIGHT: 9.5 lbs
 - 8) INSTALL D4728-053 WIRE HARNESS PER QSI 048

111961 MP
14-01-28

RELEASED
2014-01-22

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	PC	DRAWING NO.	REV. E
MFG. APPR.	RF	D4634	SHEET 3 OF 17
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CENTER CEILING PANELS	NTS
DATE	14.01.09	<small>COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D4634-043 MIDDLE, CENTER CEILING PANEL ASSY
AUXILIARY VIEW

RELEASED
 2014-01-22

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO.	REV. E
MFG. APPR.	DC	D4634	SHEET 4 OF 17
APPROVED	DC	TITLE	SCALE
DE APPR.	DC	CENTER CEILING PANELS	NTS
DATE	14.01.09	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	